Work Orde July-10-12 3:05		085	·		*870	า85*							Page 1
Item ID: Revision ID:	D407-802-0	17		A	Accept	*N90	0040	100)* ·	Setup		*N:	S1*
Item Name:	Passenger Do	or Opener Ins	stallation, LF	Ŧ							Stop	*N:	S2*
Start Date:	7/10/12	Start Qty	1.00	*1*		Cust Ite	m ID:						
Required Date:	7/10/12	Req'd Qt	y: 1.00	*1*		Custome	er:						
Reference:				**									
Approvals:	Process Pla	an:		Date: /2-07-1/	Tooling:		Date:		I		Start Stop	*NI	R1*
	QC:			Date:	SPC (Y/N):		Date:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Tool II	D Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr											
IIN-D407-802	-1 A												
*100 *100* DC			T CONTROL		0.00	6 /1/(2)(1			A.) of) H 1	MLJ	17-10-12
Document Control			Photocopy bl	uefile and create labels per l	PPP D407-802-017	002							
105	w.e	Pick Kit			0.00								
105 Packaging Packaging			Memo		0.00						· · · · · · · · · · · · · · · · · · ·		12/10/12/
	·												
*110		QC4- 100%	Inspect kits for	or completeness	0.00 SAS								
QC Quality Control			Memo		0.00	12/10/15	-		(40				

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DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							-					
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No DQ	A:	Date:	·			
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NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NO	R)						
DATE	STEP	Description of NC		Corrective Action Secti			cation	Approval	Approval			
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		ion C	Chief Eng	QC Inspector			
	-											

Work Ord July-10-12 3:0		7085		*870	185*							Page 2
Item ID: Revision ID:	D407-802-	-017 Door Opener Installation, L	u	Accept	*N900	040	100)*	Setup	Start Stop	1.71	S1* S2*
Item Name: Start Date: Required Date Reference:	7/10/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				·	"N	5/
Approvals:	Process F	Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center I 120 *120* Packaging Packaging	ID	Operation Description Packaging Memo Identify and Location: PPP rev:	pack for shipping as per	Set Up/ Run Hours 0.00 0.00 PPPD407-802-017	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp.
130 *130* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00						2/1		5 4

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W/O:			W	ORK ORDER CHANG	SES					•
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		·								
Part No	•	PAR #:	Fault Cat	egory:		Yes N	lo DQ	A:	Date:	
	R	esolution:	Dispositi	on:	QA: I	VC Clo	sed:		Date: _	
NCR:		\	WORK ORE	DER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	tion B	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector

Picklist Print *July-10-12 3:05:27 PM 87085 Work Order ID: D407-802-017 Required Date: 7/10/12 Parent Item: Start Date: 7/10/12 Passenger Door Opener Installation, LH Parent Item Name: Start Qty: 1.00 Required Qty: 1.00 IPP Rev:A 10.09.27 new issue DD verf:EC IPP Rev:B 10.12.03 as per dwg **Comments:** rev.A DD verf:EC Qty per Kit Total Component Item ID/ Replacement Last Unit of Qty on Mfg/ Bin Primary Route Qty Date Item Name Item ID Location Seq ID Measure Hand Issued Issued Purch Item Location 881011 D3552117 No 105 Each 16.0000 Manufactured Location Loc Qty Loc Code ST272 15 64338 4 65120 83585 10 ST276 69670 No 105 36.0000 Each Manufactured Location Loc Oty Loc Code

Page 1

Status

ST058 36 80406 6 82314 82314 30 105 Each D41108±1 5.0000 Manufactured No Door Doubler, Left Loc Code Location Loc Qty ST096 5 19343 79343 5 105 Each 4.0000 No Manufactured Litter Door Fitting Assembly Location Loc Oty Loc Code ST097 84010

84010

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DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Disposition	: <u>'</u>	_ QA: N/C Clo	sed:		Date: _	
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DATE	0750	Description of NC		Corrective Action Secti		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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Work Order ID:	87085								
Parent Item:	D407-802-017					Start D	eate: 7/10/12	Required Dat	e: 7/10/12
Parent Item Name:	Passenger Door Opener Installation, LI	H				Start (Qty: 1.00	Required Qt	y: 1.00
GR3528-4-03 RIVET	Purchased	No		105	Each	47.0000	12237	, 12B	
S _i			Location	Loc Qty		Loc Code		U	
			ST331	19					
			120521	19					
			ST332	28					
,			112991	10					\wedge
			116373	18				a /	(مله س
MS20426AD4-5 Rivet	Purchased	No		105	Each	4,611.0000	2 2	20	
			Location	Loc Oty		Loc Code		•	•
			ST317	4611					
			6874	4611			6874		A
MS21073L5	Purchased	No		105	Each	28.0000	1	1B	
			Location	Loc Qty		Loc Code		U	•
			ST303	28					
			120986	8			10 24/1/		
			121444	20			171444		\mathcal{A}
MS21209FT-15 HELI COIL	Purchased	No		105	Each	49.0000	3	18	Sal
			Location	Loc Oty		Loc Code		V	•
			ST305	49					
			120308	5			120308		971
			121166	44					4
MS27039C1-06 Screw	Purchased	No		105	Each	23.0000	3	JA	12//0/12
			Location	Loc Oty		Loc Code		V	
			ST293	23					
			115768	23			115168		

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W/O:			WO	RK ORDER CHANGE	S				•
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	B Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 3

Work Order ID:	87085								
Parent Item:	D407-802-017					Start	Date: 7/10/12	Required D	ate: 7/10/12
Parent Item Name:	Passenger Door Opener Installation, LH					Start	Qty: 1.00	Required	Qty: 1.00
MS27039G1-09 SCREW	Purchased	No		105	Each	113.0000	0	1 ~ JB	8
8			Location	Loc Oty		Loc Code		•	
			FP002	20				_	
			17831	20				_	
}			ST293	93				- 3	
			116290	93			116290	<u>/</u>	À ∧
MS27039G1-27 Screw	Purchased	No		105	Each	7.0000	كمس 2	2 ~ 18	
J			<u>Location</u>	Loc Qty		Loc Code			-
			ST293	7				. 6	
			115768	7			11576	<u>6</u> 8	~
NAS1149G0332R Washer	Purchased	No	\sim	105	Each	8,994.0000	123 24	18 20	Sal
			Location	Loc Qty		Loc Code		<i>V</i>	• ;
			297	8972			-	_	
			122063	8972				_	
1			ST297	22				_	
			121509	22				-	A.
NAS1149G1165R Washer	Purchased	No		105	Each	57.0000	2	2 V 1 B	
•			Location	Loc Qty		Loc Code			
, 4			ST296	57			11211	-1	(≥4 ()
			115768	57			112 16	<u>Y</u>	
NAS1149C0532R WASHER	Purchased	No		105	Each	205.0000	1224	6 4)/	12/10/1.
:			Location	Loc Qty		Loc Code			, ,
e A			ST297	205				_	
			116373	1				_	
			116513	51				_	
			119736	153				_	

W/O:			WO	ORK ORDER CHANGE	ES				•
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Work Order ID:

87085

Parent Item:

D407-802-017

Parent Item Name:

NAS1149C0563R

Washer

Passenger Door Opener Installation, LH

Purchased

No

361.0000

Start Date: 7/10/12

Start Qty: 1.00

Required Date: 7/10/12

Required Qty: 1.00

6

<u>Location</u>	Loc Oty	Loc Code	
ST296	200		
120422	200		
ST297	161		
116391	8		
117460	153		117460

Each

105

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W/O:			WC	ORK ORDER CHANG	iES					, *		
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: `	Yes N	o DQ	A:	Date:			
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DATE	STEP	Description of NC	Initial		tion B	ign &		cation	Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng		Date	Section C		Section C		Chief Eng	QC Inspector
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		,								·		
									1			

Change Record

PAGE 1 OF

Part Number:

D407-802-017

Description:

PASSENGER DOOR OPENER, LH

CHG#	DATE	BY	RELEVANT DOCUMENTS	ECN#
001	10.12.01	KJ	MDL-D407-802 REV. A	10-655
002	12.07.24	KJ	D3552 REV. K	12-624
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REFERENCE ONLY

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5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty-	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
	\times	D407-802-018	PASSENGER DOOR OPENER KIT, RH
5 1	1	D3552-17	TDOOR PROP
1_1_	1	-D3622-5	BALL STUD
1_		D4108-1	OOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
C 1_		_D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
12		MS20426AD4-5	⊋RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	THELICOIL
3	- 	MS27039C1-06	SCREW
1 1		MS27039C1-09	-SCREW
/2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6-	<u>6</u>	NAS1149C0563R	*WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
> <	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

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Revision: A

Date: 10.10.13